

213/214

Work Order ID 51847

September 4, 2009 11:24:54 AM



Page 1

Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 09-09-04 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3905	B
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IIN-D119-646	B
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100

0.00



DC

Document Control

Memo


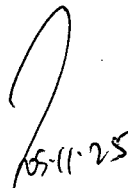

Photocopy bluefile & type labels per PPP D119-646-243
CHG 001

SCRAP

New 52975

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D119-646-243 PAR #: _____ Fault Category: skid tubes NCR: Yes No DQA: [Signature] Date: 05-11-25
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 05-11-25

NCR: 51847		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.10.22	110	AFT BEND CRUSHING, OD < 3.800" R.C. process	CP 09.10.22 pc DSI 042	PER DS. AFT BEND CRUSHING MUST BE > 3.800". NO-Web pulled. SCRAP TUBE New DT9538 was made for future bending:	 9-10-22	 15-11-25	CP R.10.22 pc DSI 042	 15-11-25

NOTE: Date & initial all entries

Work Order ID 51847

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Item ID: D119-646-243

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Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1- Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905 ✓

2- Cut FWD end of tube as per dwg D3905. ✓

3- Cut AFT end of tube as per dwg D3905. ✓

4- Buff out marks left from bending ✓

5- ~~Drill~~ Aft cap pilot hole using DT8149 ***DO NOT OPEN TO FINISHED SIZE*** ✓6- ~~Cleco~~ DT8149 in position and install drill Jig DT 9480 drill X-bolt spacer ✓7- Install DT9493 and Spot drill holes to section G using #3/16 drill. ✓

8- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" ✓

9- Drill FWD holes ✓

10- Drill Tow ring hole using DT NA Open to finished size. ✓**SCRAP**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 51847

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Item ID: D119-646-243

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Revision ID: B

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Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

0m 09 - 09 - 16 ①

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2) Sorlock 7

④

/

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> Sorlock 7

④

/

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00



Skidtubes

Memo

0.00

1-Open crossbolt spacer holes to finished size ***DO NOT OPEN SPOT
DRILLED HOLES IN SECTION G***
*Detail*2-Deburr crossbolt spacer holes as per Dwg D3905 and blow out chips from
inside the tube

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00



Quality Control

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 51847

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Revision ID: B

Item Name: Replacement Float Skidtube w/ Training Wearplates

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Start Date: 09/08/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Bond web in place as per Dwg D3905 & QSI 015.

A/R ☐ ☐ Sikaflex-291 ☐ ☐Sikaflex expire date: ☐ ☐Start: ☐ ☐ Time: ☐ ☐Finish: ☐ ☐ Time: ☐ ☐

***** (Adhere for 12 hours) *****

2--Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT
per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web
position.

3- Buff out marks left from bending.

4- Open holes of section G (spot drilled holes) to finished size.

*****VERIFY DIMENSIONS*****

5- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

0.00



Skidtubes

Memo

Skidtubes

1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before welding the other side. Use aluminum rod A/R ☐ Aluminum Rod ☐

2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole.

3-Counterbore 5/16" x 0.750" deep as per Dwg D3905.

4- Deburr & Scribe batch # on Aft end of tube.

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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A0

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Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
210	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
220	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

250

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D3905.

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51847

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Item ID: D119-646-243

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Setup Start



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Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

270



HandFinish

Hand Finishing

Memo

1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers

A/R ☐ Sikaflex-240/-291 ☐Sikaflex expire date: ☐

2- install plugs assembly as per dwg.

3 -Inspect for foreign objects as per QSI 024

4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-240/-291 ☐Sikaflex expire date: ☐**SCRAP**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51847

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Item ID: D119-646-243

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Setup Start



Revision ID: B

Item Name: Replacement Float Skidtube w/ Training Wearplates

Stop



Start Date: 09/08/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ROM

AQ

285

Wing Walk as per dwg QSI005 4.4 Batch _____

0.00



HandFinish

Memo

0.00

Hand Finishing

286

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SCRAP

DH

CH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51847

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Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

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Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

SCRAP

u 09.11.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

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Work Order ID: 51847



Parent Item: D119-646-243RevB



Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009

Required Date: 09/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190RevU/R 		Manufactured	No			110	Each	0.0000	1.0000			
Ext'n -I' Beam Tube 4"												
D3885-3RevB 		Manufactured	No			170	Each	0.0000	1.0000			
Standard Web												
D3903-1RevB 		Manufactured	No			190	Each	0.0000	12.0000			
Spacer												
D3681-1RevA 		Manufactured	No			190	Each	0.0000	8.0000			
Spacer												

Warehouse
Location
Main Warehouse
ST
47123
48178

Loc Qty
74
13
61

Loc Code

SCRAP

D3683-3RevB 		Purchased	No			250	Each	0.0000	12.0000			
Insert												
ALS4-1032-130 		Purchased	No			250	Each	5,593.000	10.0000			
Insert												

Warehouse
Location
Main Warehouse
ST
110511

Loc Qty
5593
5593

Loc Code

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D119-646-243RevB



Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009

Required Date: 09/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855-3RevB 		Manufactured	No			270	Each	0.0000	2.0000			
Cap D3672-1RevB 		Manufactured	No			270	Each	688.0000	4.0000			
Phenolic Washer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

39275

42329

47628

SCRAP

D3846-1RevB 		Manufactured	No			270	Each	0.0000	1.0000			
GASKET D3846-11RevB 		Manufactured	No			270	Each	0.0000	1.0000			
GASKET D3847-1RevB 		Manufactured	No			270	Each	0.0000	1.0000			
WEARPAD D3847-11RevB 		Manufactured	No			270	Each	0.0000	1.0000			
WEARPAD D3849-047RevB 		Manufactured	No			270	Each	0.0000	1.0000			
WEARPLATE												

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Parent Item: D119-646-243RevB

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Start Date: 09/08/2009

Required Date: 09/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3849-045RevB		Manufactured	No			270	Each	0.0000	1.0000			
AFT WEARPLATE ASSY, FLOAT GEAR												
D3904-1RevB		Manufactured	No			270	Each	0.0000	16.0000			
Washer												
D3672-3RevB		Manufactured	No			270	Each	419.0000	12.0000			
Phenolic Washer												
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>34471</div> <div>48258</div> </div> <div> <div>Loc Qty</div> <div>419</div> <div>56</div> <div>363</div> </div> <div> <div>Loc Code</div> </div>												
AN3C5A		Purchased	No			270	Each	646.0000	14.0000			
Bolt												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	646	
111424	8	
111707	338	
112314	200	
112489	100	

September 4, 2009 11:24:54 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 4, 2009 11:24:54 AM

Work Order ID: 51847



Parent Item: D119-646-243RevB



Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009

Required Date: 09/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C46A BOLT		Purchased	No			270	Each	114.0000	4.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

114

106169

106176

111918

100

AN960C10L

Purchased

No



washer

270

Each

2,450.000

10.0000



Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG

100

103585

100

Main Warehouse

FP

-44

112116

-44

Main Warehouse

ST

2394

112116

2394

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 4, 2009 11:24:54 AM

Work Order ID: 51847



Parent Item: D119-646-243RevB



Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 09/08/2009

Required Date: 09/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C416 washer		Purchased	No			270	Each	706.0000	12.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST

100993

706

MS21043-3

Purchased

No

270

Each

5,324.000

8.0000

Nut

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

5244

111819

78

112243

190

112314

4976

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 4, 2009 11:24:54 AM

Work Order ID: 51847

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates


Start Date: 09/08/2009

Required Date: 09/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039C4-08  SCREW		Purchased	No			270	Each	117.0000	12.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

17831

AN3C50A

Purchased

No



Bolt

Warehouse

Location

Main Warehouse

ST

112046

112454

Loc Qty

60

10

50

Loc Code

270

Each

0.0000

16.0000

D3411-3RevREVA

Manufactured

No



WASHER

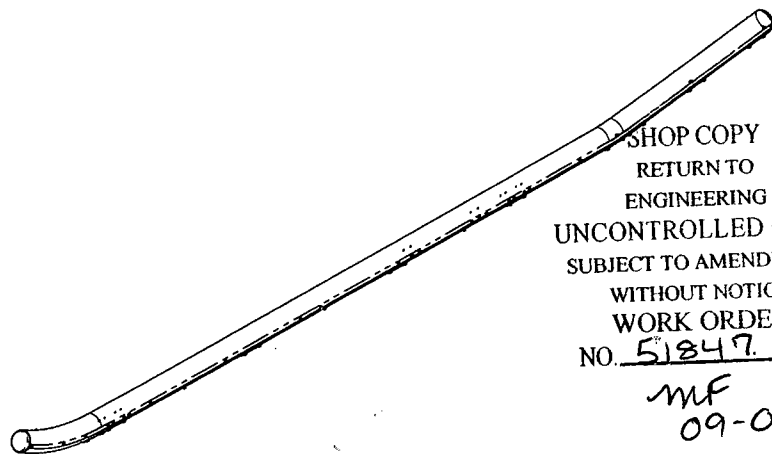
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

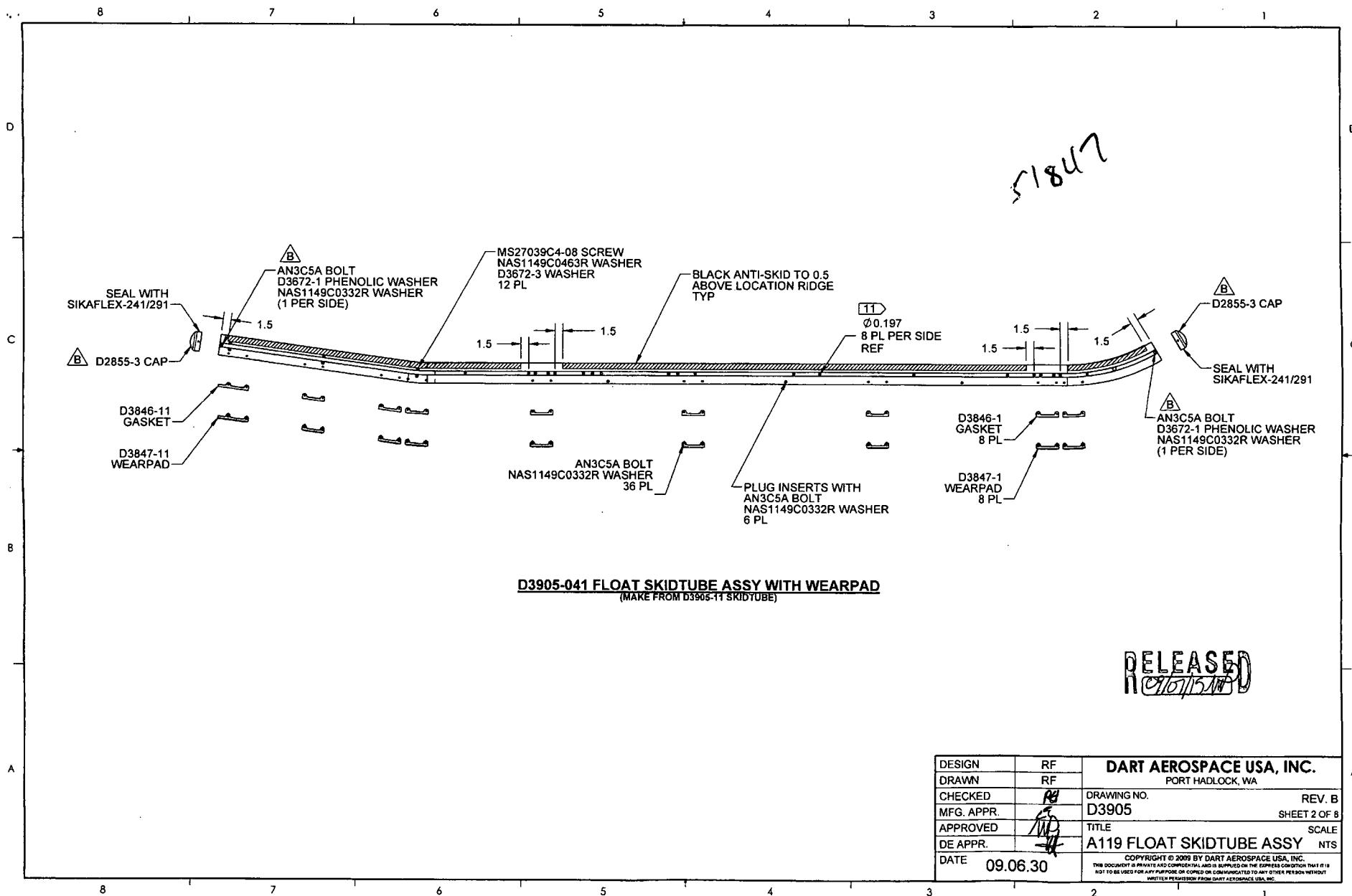
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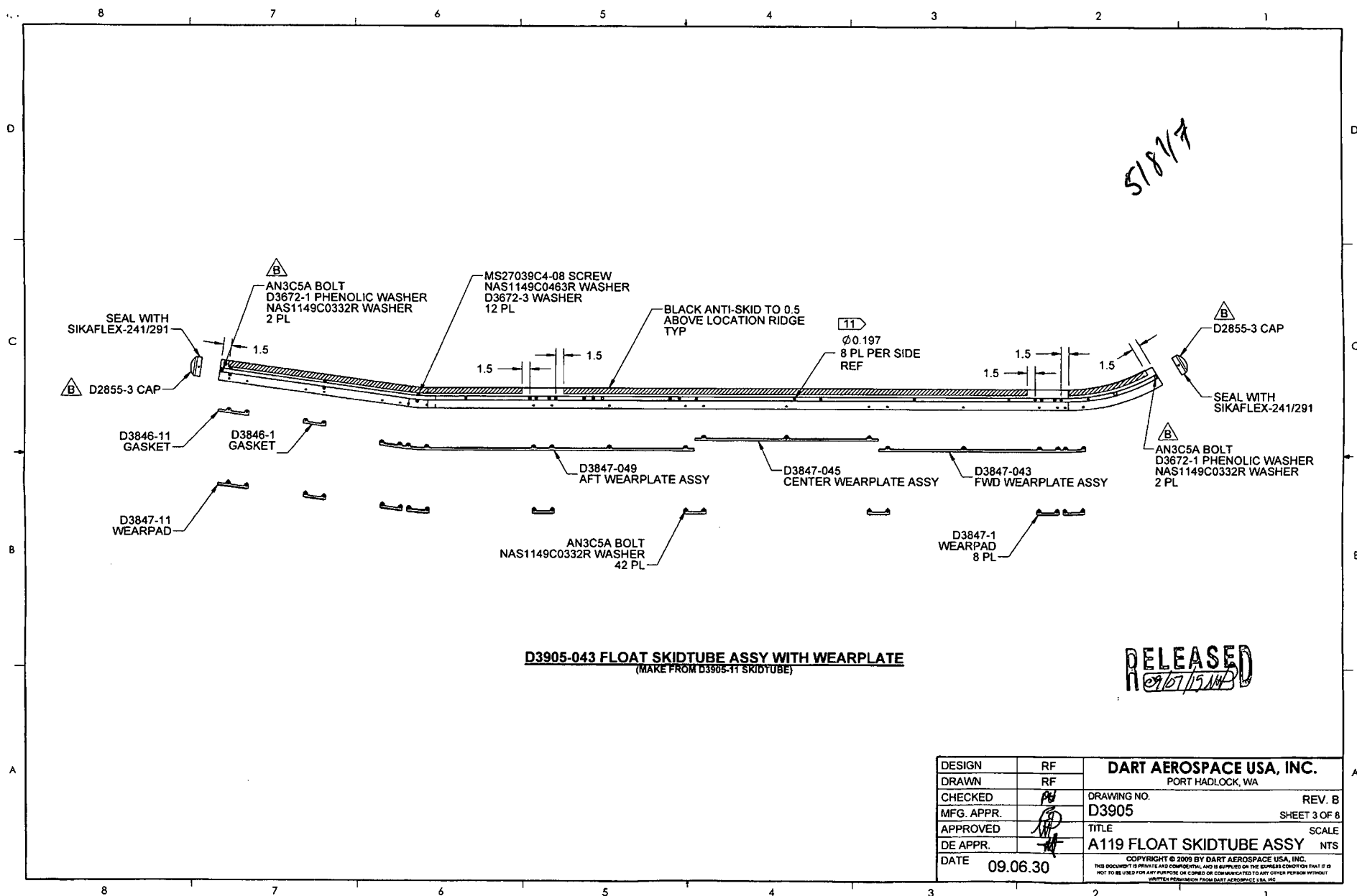
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.7 lbs
D3905-043 = 47.0 lbs
D3905-045 = 47.3 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES
ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT
PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT
PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE
WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO $\phi 0.197$ HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL $\phi 0.297$ HOLES FOR WEARPLATE INSERTS.
INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS
WITH SIKAFLEX-241/-291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	8	1	1	D3846-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-047	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
31			16	D3411-3	WASHER
41	42	42	10	ALS4-1032-130	INSERT
42	46	46	14	AN3C5A	BOLT
43			4	AN3C46A	BOLT
44			4	AN3C50A	BOLT
45	46	46	10	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C418)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW

RELEASED
09/07/13

B	REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A8-5, A5-6, C5-7, C3-7, A5-7); ADD DT8832 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); $\phi 0.313$ WAS $\phi 0.328$ (B2-5, B2-6, C2-7, A8-7 & D7-8); REVISED NOTE IV (ZN A8-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 1 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
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51849

SEAL WITH
SIKAFLEX-241/291

△
D2855-3 CAP

D3846-11 GASKET

D3847-11
WEARPAD

AN3C5A BOLT
NAS1149C0332R WASHER
10 PL

△
AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

1.5

D3846-1
GASKET

D3847-1
WEARPAD

MS27039C4-08 SCREW
NAS1149C0463R WASHER
D3672-3 WASHER
12 PL

1.5

1.5

D3849-045
AFT TRAINING WEARPLATE ASSY

AN3C46A BOLT
D3904-1 WASHER, 2 PL
MS21043-3 NUT
4 PL

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

1.5

1.5

1.5

△
D3849-047
FWD TRAINING WEARPLATE ASSY

△
AN3C50A BOLT
D3904-1 WASHER, 2 PL
D3411-3 WASHER, 4 PL
MS21043-3 NUT
4 PL

△
D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

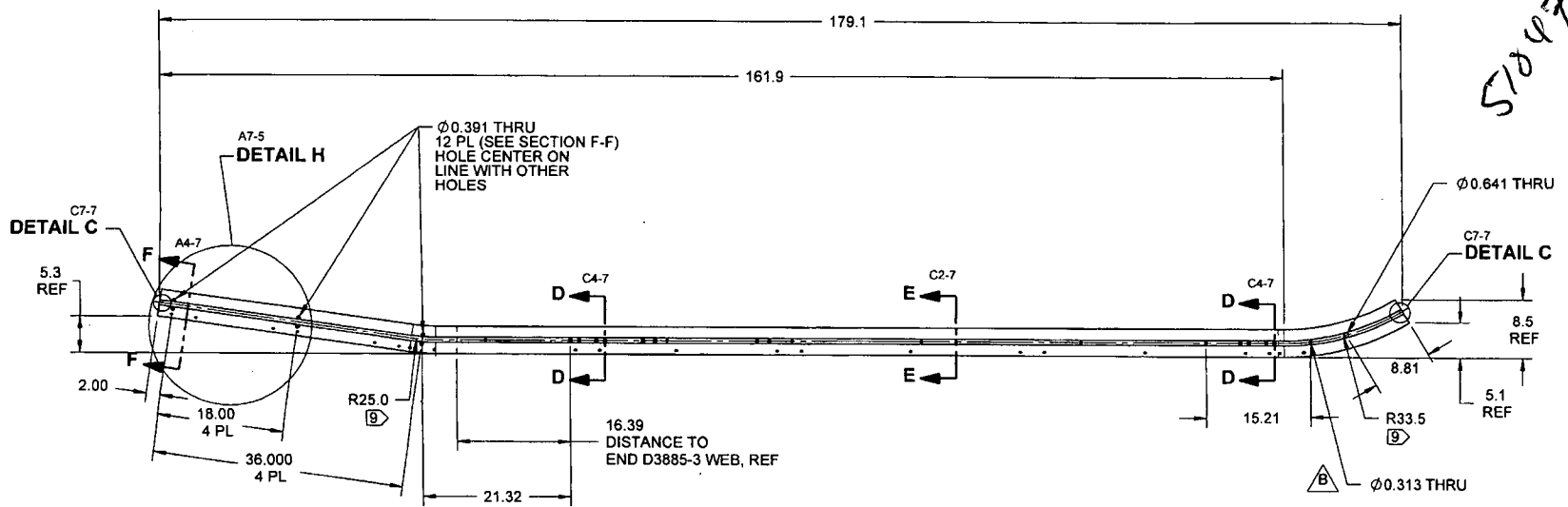
△
AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
2 PL

D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
(MAKE FROM D3905-13 SKIDTUBE)

RELEASED
27/07/15

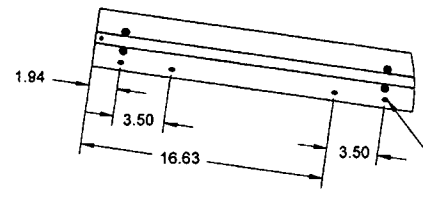
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8 7 6 5 4 3 2 1



51047

D3905-11 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)



DETAIL H
SCALE 2X C7-5

DRILL $\phi 0.297$
INSTALL ALS4-1032-130 INSERT
AFTER FINISH, SEE SECTION F-F
TYP, 2 PL

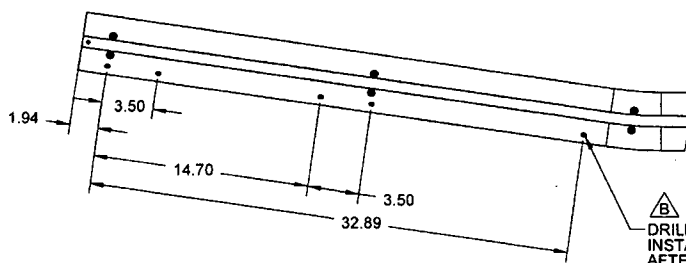
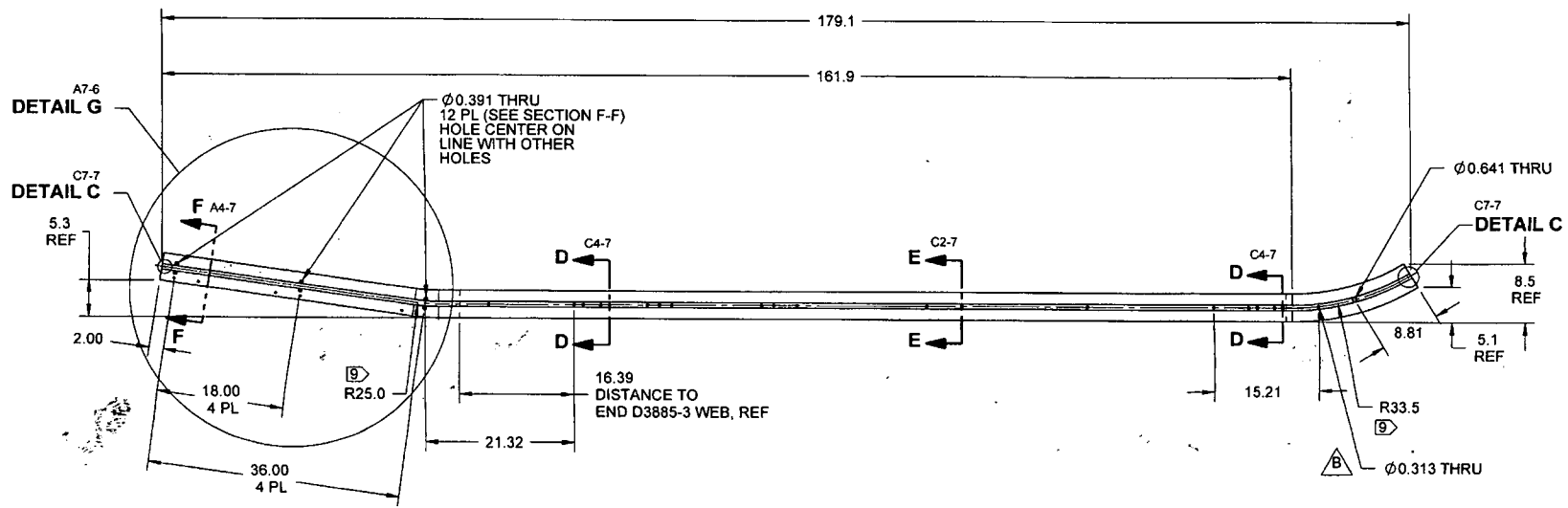
RELEASED
07/15/11

DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	RF	DRAWING NO. D3905	REV. B
MFG. APPR.	RF	SHEET 5 OF 8	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	
DATE	09.06.30	NTS	

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8 7 6 5 4 3 2 1

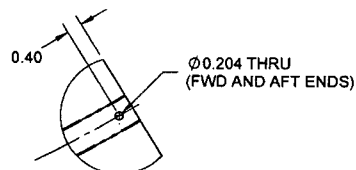
51847



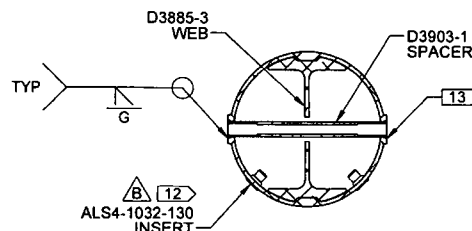
D3905-13 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)

RELEASED
29/07/15 N/A

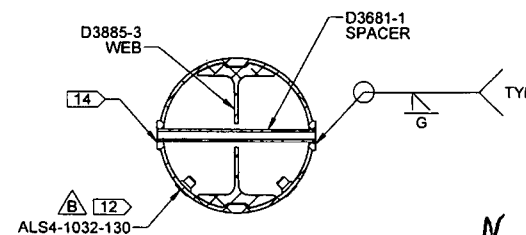
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DETAIL C
SCALE 4X
C1-5
C8-5
C8-6
C1-6

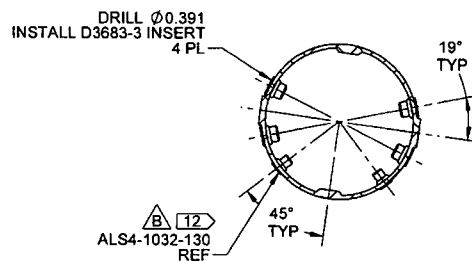


SECTION D-D
SCALE 4X
C5-5
C2-5
C5-6
C2-6
(FOR 12 x $\phi 0.375$ HOLES
PER SKIDTUBE)



SECTION E-E
SCALE 4X
C4-5
C4-6
(FOR 8 x $\phi 0.313$ HOLES
PER SKIDTUBE)

5/10/17



SECTION F-F
SCALE 4X
C7-6
C7-5

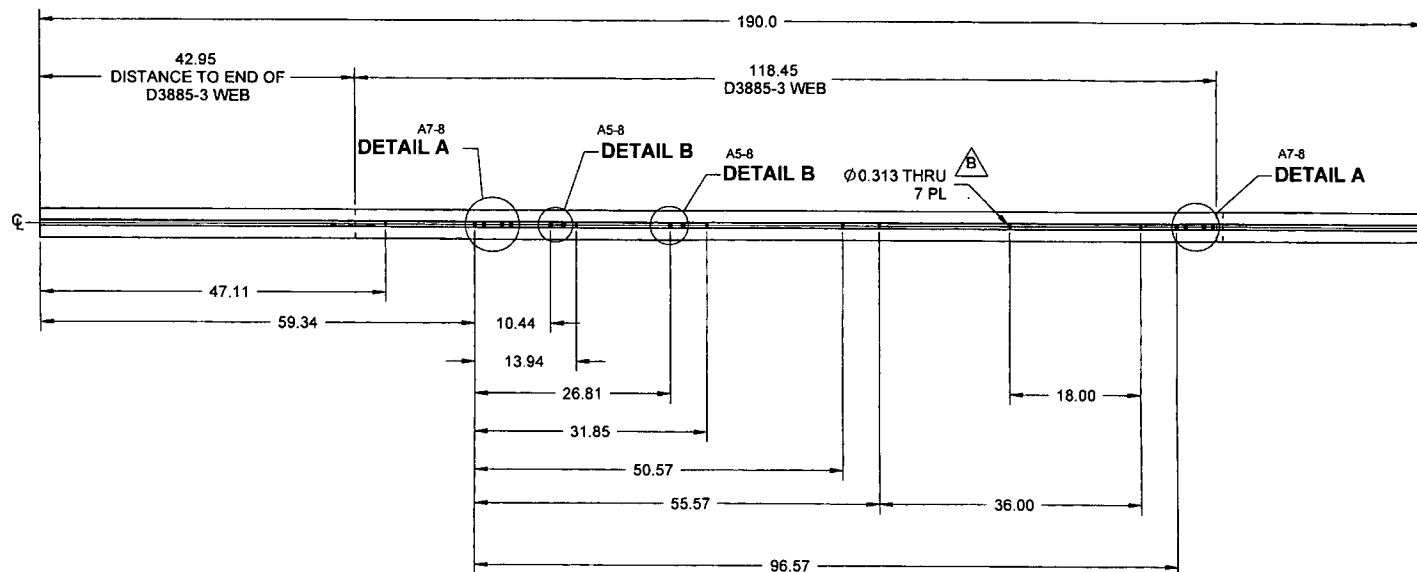
NOTES:

- 13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$ HOLES ONLY:
i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$ (BOTH SIDES)
ii) INSERT D3903-1 SPACER
iii) WELD INTO PLACE AND GRIND FLUSH
iv) C'BORE TO 0.313×0.75 DEEP
v) DEBURR HOLES

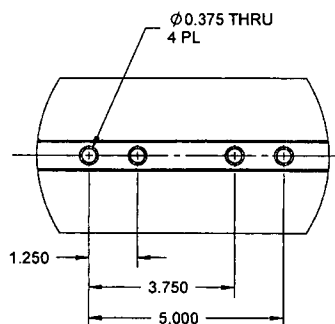
- 14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.313$ HOLES ONLY:
vi) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
vii) INSERT D3681-1 SPACER
viii) WELD INTO PLACE AND GRIND FLUSH
ix) DEBURR HOLES

RELEASED
09/07/15/17

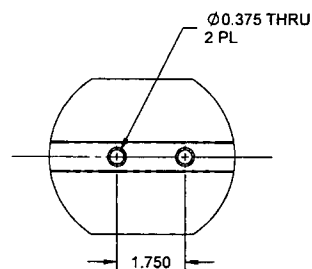
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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 7 OF 8
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D3905-1 TUBE
(MAKE FROM D2500-1-190 EXTRUSION)



DETAIL A D6-8
SCALE 4X D2-8



DETAIL B D5-8
SCALE 4X D4-8

RELEASED
09/07/15

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MFG. APPR.		D3905	SHEET 8 OF 8
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